

CLAIMS

1. A method of manufacturing a diamond tool having a shank and a plurality of abrasives attached thereto, comprising the steps of:

forming a plurality of concave portions in a surface of the shank; and

bonding a plurality of abrasives to an inner space of the concave portion.

2. The method as claimed in claim 1, wherein the step of bonding a plurality of the abrasives to the inner space includes a brazing method.

3. The method as claimed in claim 2, wherein the step of bonding a plurality of the abrasives to the inner space comprises the steps of:

preparing a mixture of a bonding material of paste form and a plurality of abrasives;

filling the mixture into the concave portion; and

heating the shank to thereby perform a fusion bonding.

4. The method as claimed in claim 2, wherein the step of bonding a plurality of the abrasives to the inner space comprises the steps of:

filling a bonding material of paste form into the concave portion;

disposing a plurality of abrasives in the concave portion to be dispersed in the bonding material;

drying the bonding material; and

heating the shank to thereby perform a fusion bonding .

5. The method as claimed in claim 1, wherein the step of bonding a plurality of the abrasives to the inner space comprises an electroplating method.

6. The method as claimed in claim 5, wherein the step of bonding a plurality of the abrasives to the inner space comprises the steps of:

coating a non-conductive film onto the surface of the shank except the concave portions;

disposing a plurality of abrasives in the concave portion; and

electroplating the shank.

7. The method as claimed in claim 6, further comprising the step of removing the non-conductive film.

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8. The method as claimed in claim 1, wherein the step of bonding a plurality of the abrasives to the inner space further comprises the step of disposing the abrasive in such a way that the abrasive protrudes from the surface of the shank.

10 9. The method as claimed in claim 1, further comprising the step of bonding a plurality of abrasives onto the top of the concave portion, to which the abrasives and bonding material are bonded, and onto the surface of the shank.

15 10. The method as claimed in claim 9, wherein the step of bonding a plurality of the abrasives onto the top comprises the steps of:

coating a bonding material of paste form on the top of the concave portion and on the surface of the shank;

dispersing a plurality of abrasives in the bonding material,

drying the second bonding material; and

20 heating the shank to thereby perform a fusion bonding .

11. The method as claimed in claim 1, further comprising the step of bonding a plurality of abrasives onto the surface of the shank and onto the top of the concave portion, to which the abrasives and bonding material are bonded, wherein the step of bonding a plurality of
25 the abrasives onto the surface of the shank and onto the top of the concave portion comprises the steps of disposing a plurality of abrasives on the top of the concave portion and on the surface of the shank; and electroplating the shank.

12. A method of manufacturing a diamond tool having a shank and a plurality of
30 abrasives attached thereto, comprising the steps of:

forming a plurality of concave portions in a surface of the shank;
filling a bonding material of paste form and a plurality of abrasives into the concave
portion;

5 coating a bonding material of paste form on the top of the concave portion, to which the
filled bonding material and abrasives are bonded, and onto the surface of the shank;
dispersing a plurality of abrasives in the bonding material;
drying the bonding materials; and
heating the shank to thereby perform a fusion bonding.

10 13. The method as claimed in claim 12, further comprising the step of drying the
bonding material within the concave portion before the step of coating the bonding material.

15 14. The method as claimed in claim 12, wherein the fusion bonding is carried out
within a batch type vacuum furnace, a reduction/inert gas atmosphere furnace, or a continuous
gas atmosphere furnace using a conveyor.

20 15. The method as claimed in claim 10, wherein the fusion bonding is carried out
within a batch type vacuum furnace, a reduction/inert gas atmosphere furnace, or a continuous
gas atmosphere furnace using a conveyor.

25 16. A diamond tool having a shank and a plurality of abrasives attached thereto,
wherein a plurality of concave portions are formed in a surface of the shank and a plurality of
abrasives are bonded into the concave portions.

30 17. The diamond tool as claimed in claim 16, wherein the concave portion includes a
dimple type one and a groove type one.

18. The diamond tool as claimed in claim 17, wherein a cross section of the concave
portion taken along a direction perpendicular to the surface of the shank includes a semicircular
shape, a semi-elliptic shape, a U-shape, a V-shape, or a wavy shape.

19. The diamond tool as claimed in claim 16, wherein a wall between the concave portions has a rounded upper end edge.

20. The diamond tool as claimed in claim 16, wherein the concave portion includes a through-hole type concave portion.

21. The diamond tool as claimed in claim 16, wherein a groove is formed in a main cutting face of the shank and a through-hole is formed in a sub-cutting face of the shank.

22. The diamond tool as claimed in claim 16, wherein a ratio (s/w) of the spacing (s) between the concave portions to the width (w) of the concave portion is within a range of 0.2 to 0.8.

23. The diamond tool as claimed in claim 16, wherein a ratio (w/s) of the width (w) of the concave portion to the maximum diameter (a) of the abrasive is greater than 0.25.

24. The diamond tool as claimed in claim 16, wherein a ratio (d/a) of the depth (d) of the concave portion to the maximum diameter (a) of the abrasive is greater than 0.25.

25. The diamond tool as claimed in claim 16, wherein a plurality of abrasives is bonded onto the top of the concave portion, to which the abrasives and bonding material are bonded, and onto the surface of the shank.

26. The diamond tool as claimed in claim 25, wherein the protruding height of the plurality of abrasives bonded to the top of the concave portion and the surface of the shank is varied.

27. The diamond tool as claimed in claim 16, wherein a protruding height of the abrasives is varied.

28. The diamond tool as claimed in claim 16, wherein the diamond tool includes a saw, a core drill, a cutter, a saw blade, a wire saw, a polishing cup, a profiler, an end mill, a straight wheel, an ID wheel, a rotary dresser, and an edge grinding wheel.

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29. The diamond tool as claimed in claim 16, wherein the abrasive includes synthetic and natural diamond, cubic boron nitride (cBN), silicone carbide, alumina, and a mixture of at least two thereof.